

Date: Tuesday, 31/03/2009 1:04:54 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT WELDMENT ASS'Y
Job Number :	46750		
Estimate Number :	10554		
P.O. Number :		Part Number :	D34431
This Issue :	31/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3443 REV B
First Issue :	//	Project Number :	N/A
Previous Run :	46143	Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	07/04/2009
Written By :		Qty:	8
Checked & Approved By :	<u>JLW 09.03.31</u>	Um:	Each
Comment :	A 05.11.14 New issue EC Est Rev:B Removed Tumbling 08-09-08 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M174B2500X1250

17-4 SS BAR 2.500 x 1.250



Comment: Qty.: 0.2100 f(s)/Unit Total: 1.6800 f(s)

Material: 17-4 SS Bar 2.500" X 1.250"

(M17-4-B2.500x01.250)

Batch: M110378

J.L 09/03/31

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blank 2.400" long

J.L 09/03/31

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA587 Rev: AA & Dwg D3443 Rev: B

mmf 09/04/02

(PTO) - 2

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/04/02

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

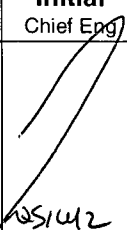
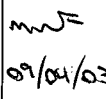
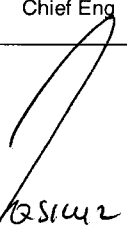

J.F. 09/04/02

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3443-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/04/09

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46750</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/03	3.0	Drill bit broke in place R.C. process.		Scrap No replace Qty 1	 09/04/03	J.F. 09/04/06		

NOTE: Date & initial all entries

Date: Tuesday, 31/03/2009 1:04:54 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 46750

Part Number: D34431

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *one*

29/4/09 (7)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/09
[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: 46750
Description: Lug		Part Number: D3443-1
Inspection Dwg: D3443	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.000	✓			
0.342	+0.000/-0.005	.340	✓			
0.329	+/-0.010	.329	✓			
Ø0.500	+0.000/-0.005	.499	✓			
2.21	+/-0.030	2.21	✓			
Ø0.656	+0.000/-0.001	Ø .656	✓			
0.625	+/-0.010	.626	✓			
0.95	+/-0.030	.95	✓			
2.230	+/-0.010	2.230	✓			
0.229	+/-0.010	.231	✓			
0.370	+/-0.010	.370	✓			
0.525	+/-0.010	.525	✓			
0.524	+/-0.010	.524	✓			
0.390	+/-0.010	.388	✓			
1.048	+/-0.010	1.047	✓			
0.05 x 45°	+/-0.5°	.05 x 45°	✓			
R0.032	+/-0.010	R.032	✓			
0.470	+/-0.010	.469	✓			
0.165	+/-0.010	.163	✓			
1/4-28UNF	N/A	1/4-28 UNF	✓			

Measured by: MME	Audited by: J.F.	Prototype Approval:	N/A
Date: 09/04/02	Date: 09/04/06	Date:	N/A

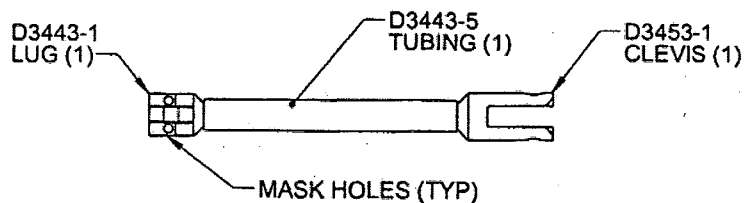
Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM	FE



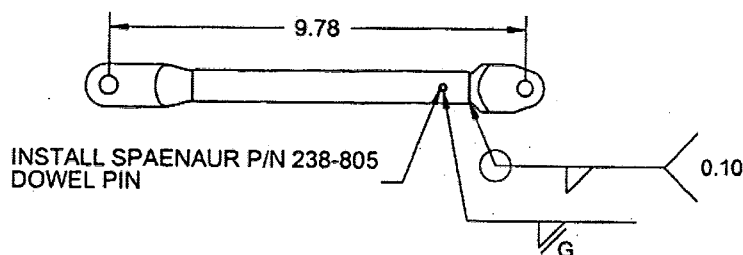
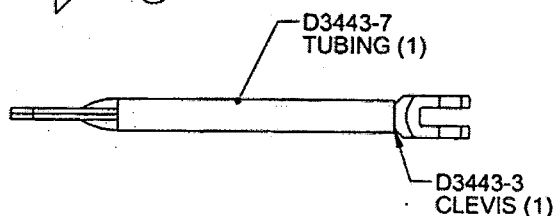
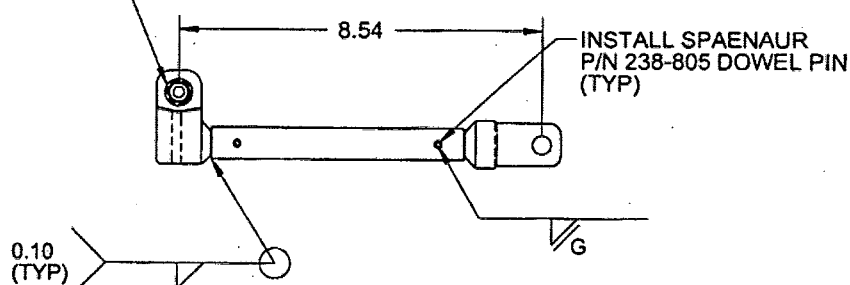
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED

05.12.09 *[Signature]*

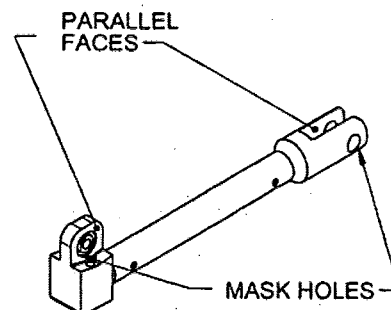


PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

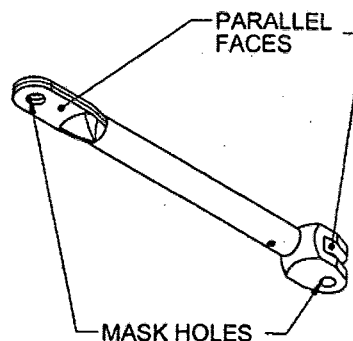


NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



D3443-041



D3443-043

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

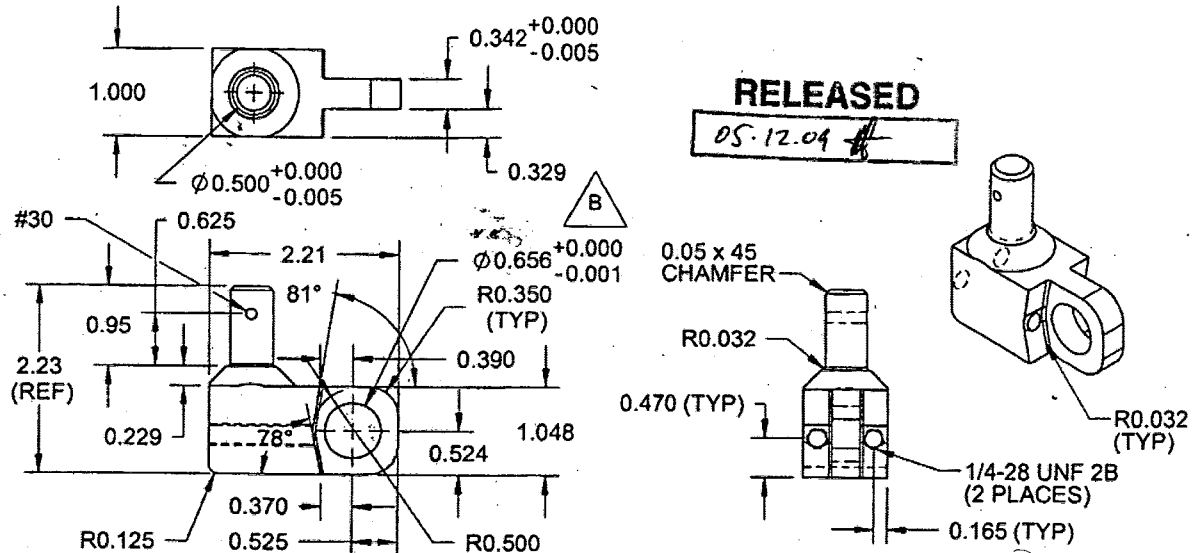
NO. *HL 750*

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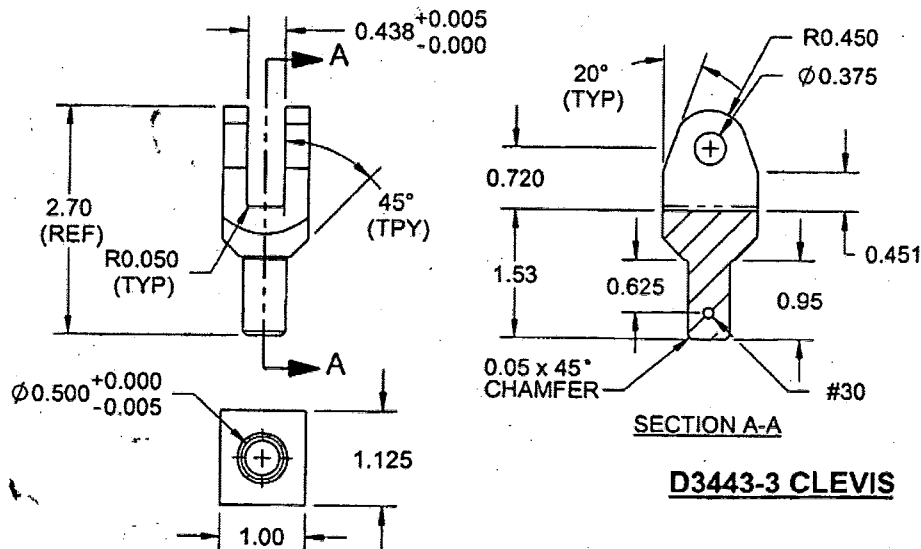
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DART

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CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R) SUBJECT TO AMENDMENT WITHOUT NOTICE
- GENERAL NOTES:**
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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WORK ORDER
46750

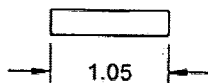
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

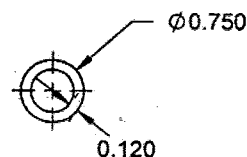
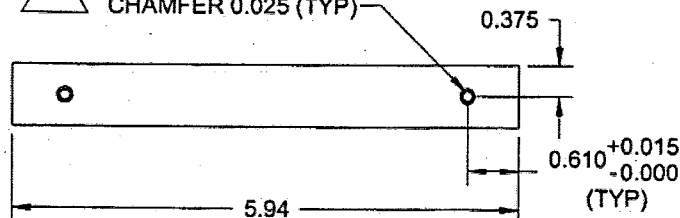
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09

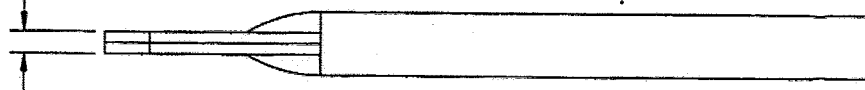


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

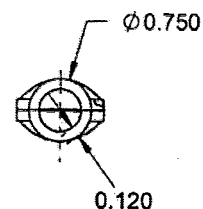


D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



DRILL $\phi 0.125$ THRU
CHAMFER 0.025



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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